



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4103-1
Job Sheet 167662



Part No: D4103-1

Job Qty: 4 ea

Part Name: Step / Handle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/5/17

Job Tracking No:

Due Date: 11/17/17

Created By: Linda Lacelle

Type: **SOLD**

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/16/17	11/16/17	0.00	0.00	Start Up Machining		KT 17-11-07
100	Bandsaw	4 pcs	11/16/17	11/16/17	0.00	3.25	Bandsaw1		KT 17-11-07
110	CNC Vertical Machining	4 pcs	11/16/17	11/16/17	0.12	5.13	HAAS 1		
130	QC	4 pcs	11/16/17	11/16/17	0.00	0.00	QC8		FK 17-11-10
140	HandFinish	4 pcs	11/17/17	11/17/17	0.00	0.28	HandFinish1		DAS
150	QC	4 pcs	11/17/17	11/17/17	0.00	0.00	QC3		38
160	Packaging	4 pcs	11/17/17	11/17/17	0.00	0.00	Packaging3	57 076	OCT 14 2017
170	QC21-SA	4 Ea	11/17/17	11/17/17	0.00	0.00	QC21		

Part Op 100 - 6.200" long

Descriptions: 110 - Mill as per dwg and Folio FA937

DAS
21
8-00

NOV 14 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B2.000X03.500	2	0	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step/Handle	2.930Inches $\pm$ 0.030	2.960 2.900		
2	Step/Handle	0.370Inches $\pm$ 0.030	0.400 0.340		
3	Step/Handle	0.830Inches $\pm$ 0.030	0.860 0.800		
4	Step/Handle	0.560Inches $\pm$ 0.010	0.570 0.550	Diameter	
5	Step/Handle	0.060Inches $\pm$ 0.030	0.090 0.030		
6	Step/Handle	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
7	Step/Handle	0.260Inches $\pm$ 0.030	0.290 0.230		
8	Step/Handle	0.330Inches $\pm$ 0.030	0.360 0.300		
9	Step/Handle	0.060Inches $\pm$ 0.030	0.090 0.030	Radius	

DART
AEROSPACE
S008490



Step / Handle

PART NO: D4103-1
Revision:
Operation: Start up Operation
Change No:

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Mfg Date: 11/09/17
Job No: 167662

10	Step/Handle	1.780Inches $\pm$ 0.030	1.810 1.750	
11	Step/Handle	0.450Inches $\pm$ 0.030	0.480 0.420	
12	Step/Handle	0.330Inches $\pm$ 0.030	0.360 0.300	
13	Step/Handle	0.750Inches $\pm$ 0.000 - 0.030	0.750 0.720	
14	Step/Handle	1.660Inches $\pm$ 0.030	1.690 1.630	
15	Step/Handle	0.800Inches $\pm$ 0.030	0.830 0.770	
16	Step/Handle	1.070Inches $\pm$ 0.030	1.100 1.040	
17	Step/Handle	3.850Inches $\pm$ 0.030	3.880 3.820	
18	Step/Handle	0.030Inches $\pm$ 0.030	0.060 0.000	
19	Step/Handle	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle
20	Step/Handle	0.310Inches $\pm$ 0.030	0.340 0.280	
21	Step/Handle	0.280Inches $\pm$ 0.030	0.310 0.250	
22	Step/Handle	0.030Inches $\pm$ 0.030	0.060 0.000	Depth
23	Step/Handle	6.000Inches $\pm$ 0.030	6.030 5.970	
24	Step/Handle	0.270Inches $\pm$ 0.030	0.300 0.240	Radius
25	Step/Handle	0.560Inches $\pm$ 0.030	0.590 0.530	
26	Step/Handle	1.740Inches $\pm$ 0.030	1.770 1.710	
27	Step/Handle	2.500Inches $\pm$ 0.030	2.530 2.470	
28	Step/Handle	0.438Inches $\pm$ 0.006 - 0.001	0.444 0.437	Diameter
29	Step/Handle	0.266Inches $\pm$ 0.006 - 0.001	0.272 0.265	Diameter
30	Step/Handle	0.960Inches $\pm$ 0.030	0.990 0.930	
31	Step/Handle	0.260Inches $\pm$ 0.030	0.290 0.230	
32	Step/Handle	0.250Inches $\pm$ 0.030	0.280 0.220	
33	Step/Handle	2.250Inches $\pm$ 0.030	2.280 2.220	
34	Step/Handle	1.000Inches $\pm$ 0.030	1.030 0.970	
35	Step/Handle	0.200Inches $\pm$ 0.030	0.230 0.170	
36	Step/Handle	0.980Inches $\pm$ 0.030	1.010 0.950	
37	Step/Handle	0.320Inches $\pm$ 0.030	0.350 0.290	
38	Step/Handle	1.250Inches $\pm$ 0.030	1.280 1.220	
39	Step/Handle	0.190Inches $\pm$ 0.030	0.220 0.160	Radius

DART AEROSPACE LTD		Work Order:	167662
Description: Step/Handle		Part Number:	D4103-1
Inspection Dwg: D4103 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.93	+/-0.030	2.932			VERN	SBL-01
0.37	+/-0.030	.368			"	"
0.83	+/-0.030	.833			"	"
Ø0.560	+/-0.010	.560			D.Well pin	
0.06 X 45°	+/-0.030 X +/-0.5°	.063 X 45°			VERN	
0.26	+/-0.030	.260			D-G	310006
0.33	+/-0.030	.330			VERN	SBL-01
R0.06	+/-0.030	.062			"	"
1.78	+/-0.030	1.79			"	"
0.45	+/-0.030	.440			"	"
0.33	+/-0.030	.330			"	"
0.75	+0.000/-0.030	.750			"	"
1.66	+/-0.030	1.640			"	"
0.80	+/-0.030	.770			"	"
1.07	+/-0.030	1.070			"	"
3.85	+/-0.030	3.851			"	"
0.03 X 45°	+/-0.030 X +/-0.5°	.060 X 45°			"	"
0.31	+/-0.030	.305			"	"
0.28	+/-0.030	.281			"	"
0.030 Deep	+/-0.030	.030			"	"
6.00	+/-0.030	6.003			"	"
R0.27	+/-0.030	.270			"	"
0.56	+/-0.030	.560			"	"
1.74	+/-0.030	1.74			"	"
2.50	+/-0.030	2.500			"	"
Ø0.438	+0.006/-0.001	.440			D.Well pin	
Ø0.266	+0.006/-0.001	.266			D.Well pin	
0.96	+/-0.030	.947			"	"
0.26	+/-0.030	.255			"	"
0.25	+/-0.030	.235			"	"
2.25	+/-0.030	2.251			"	"
1.00	+/-0.030	1.000			"	"
0.20	+/-0.030	.185			"	"
0.98	+/-0.030	.990			"	"
0.32	+/-0.030	.345			"	"
1.25	+/-0.030	1.250			"	"
R0.19	+/-0.030	.190			"	"

Measured by: SBL/mrk	Audited by: F.K.	Preliminary Approval:
Date: 17/11/08	Date: 17-11-10	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	M